

Work Order ID 58849

Wednesday, May 19, 2010 1:40:45 PM



Page 1

Item ID: D3908-3

Accept



Setup Start



Revision ID:

Item Name: Stud Receiver, Lower

Stop



Start Date: 5/19/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3908	B

100



Cut blanks as per folio

0.00

3 8

Bandsaw

Memo

0.00

CUT BLANK 4.00" LONG

110



HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

3 8

MACHINE AS PER FOLIO FA866 AND DWG

FOLIO REV: A4

DWG REV: B

DEBURR

W/O:		WORK ORDER CHANGES					
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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

ML 10/06/01

3 0

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

MV
10/06/02

3 0

160



Packaging

Packaging

Identify as per dwg & Stock Location: ST

0.00

Memo

0.00

ML 10-5-02

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Page 3

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Setup

Start



Revision ID:

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Stop



Start Date: 5/19/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberReject
Stamp

QC

Memo

0.00

Quality Control

10/06/02 HJ
MF 10-6-02

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Picklist Print

Wednesday, May 19, 2010 1:40:50 PM

Page 1

Work Order ID: 58849



Parent Item: D3908-3



Parent Item Name: Stud Receiver, Lower

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP REV:A NEW ISSUE 09-11-24 JLM VERIFIED BY:DD IPP Rev:B
as per dwg revB DD 10.04.20 verified by:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M303B1.000X2.000			No			100	f	1.4842	0.333333			

303 BAR 1" X 2"

Location	Loc Qty	Loc Code
MAT53	1.48417	
113390	1.48417	

1.48417 05/19/2010 10:57:27

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DART AEROSPACE LTD	Work Order:	58840
Description: Stud Receiver Lower	Part Number:	D3908-3
Inspection Dwg: D3908 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.25	+0.005/-0.001	.257	/			
0.625	+/-0.010	.627	/			
0.368	+/-0.010	.365	/			
Ø0.453	+0.010/-0.000	.454	/			
1.95	+/-0.030	1.941	/			
Ø0.38	+0.006/-0.001	.379	/			
0.63	+/-0.030	.624	/			
2.43	+/-0.030	2.422	/			
0.63	+/-0.030	.624	/			
0.75	+/-0.030	.749	/			
0.38	+/-0.030	.375	/			
R0.06	+/-0.030	R.060	/			
R0.25	+/-0.030	R.250	/			
3.80	+/-0.030	3.800	/			
0.735	+0.000/-0.010	.729	/			
Ø0.129	+0.005/-0.001	.129	/			
1.25	+/-0.030	1.250	/			
15°	+/-0.5 °	15°	/			
1.587	+/-0.010	1.582	/			
1.588	+/-0.010	1.582	/			
0.31	+/-0.030	.312	/			
0.750	+/-0.010	.757	/			
0.95	+/-0.030	.950	/			
0.99	+/-0.030	.990	/			
90°	+/-0.5°	90°	/			
0.06 x 45°	+/-0.030 x 0.5°	0.06x45°	/			
0.80	+/-0.030	.800	/			

Measured by:	<i>Arn</i>	Audited by:	<i>MME</i>	Preliminary Approval:	
Date:	10/06/01	Date:	10/06/01	Date:	

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.04.20	Dwg Rev updated	KJ	<i>AA</i>

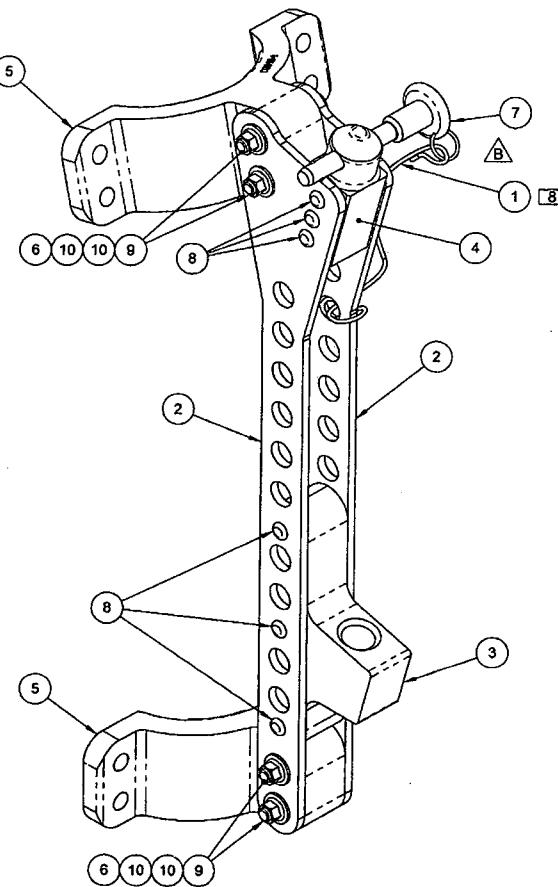
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ITEM	QTY.	P/N	DESCRIPTION
X	1	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	4	AN3C12A	BOLT
7	1	MS17984-C413	PIP PIN
8	6	MS20615-4M20	RIVET
9	4	MS21043-3	NUT
10	8	NAS1149C0332R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.35 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

SHEET 5 OF 5
 REV. B
 ENGINEERED
 UNCONTROLLED
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER NO. 58849
 28/05/19

RELEASED
 2010-04-14
 MP

B	BOM: D3908-S REPLACED WITH D3908-5. QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-S		JPH	10.04.06
A	NEW ISSUE			
REV.	DESCRIPTION			
DESIGN	JPH	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	JPH	DRAWING NO.	REV. B	
MFG. APPR.	JPH	D3908	SHEET 1 OF 5	
APPROVED	JPH	TITLE	SCALE	
DE APPR.	JPH	X-TUBE LUG ASSY (AFT)	NTS	
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY MATERIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISCLOSED EXCEPT BY ANOTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

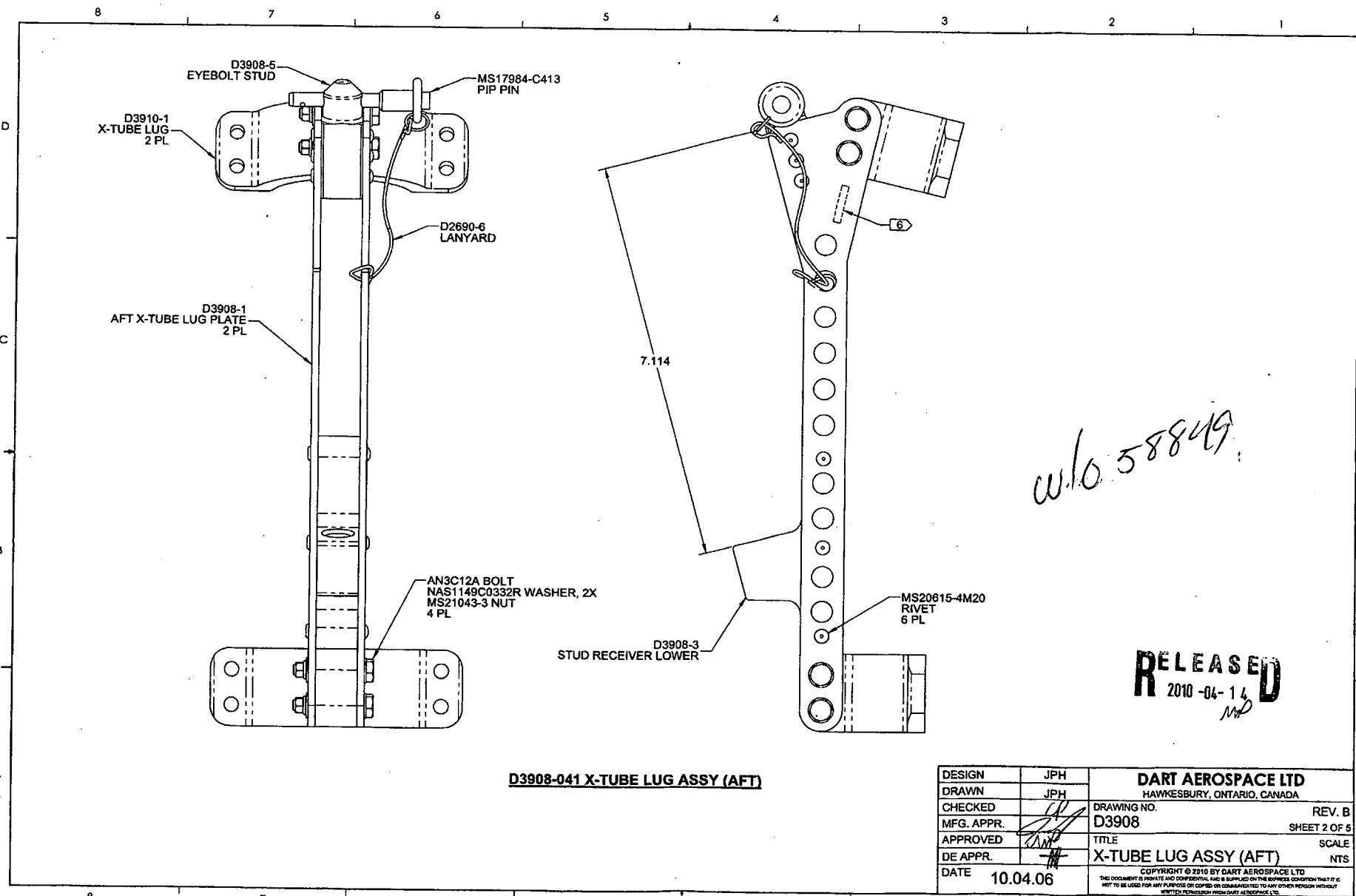
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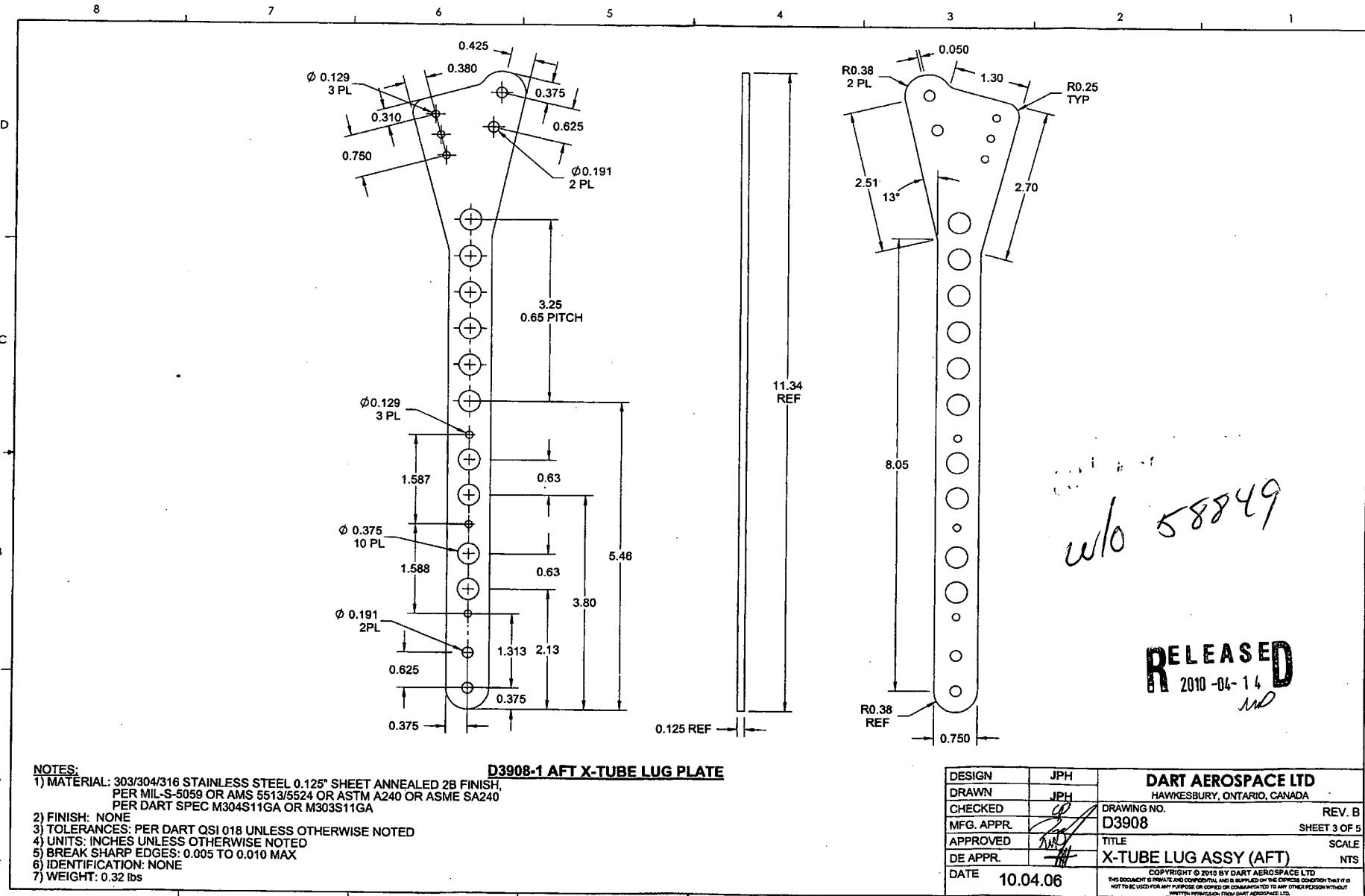


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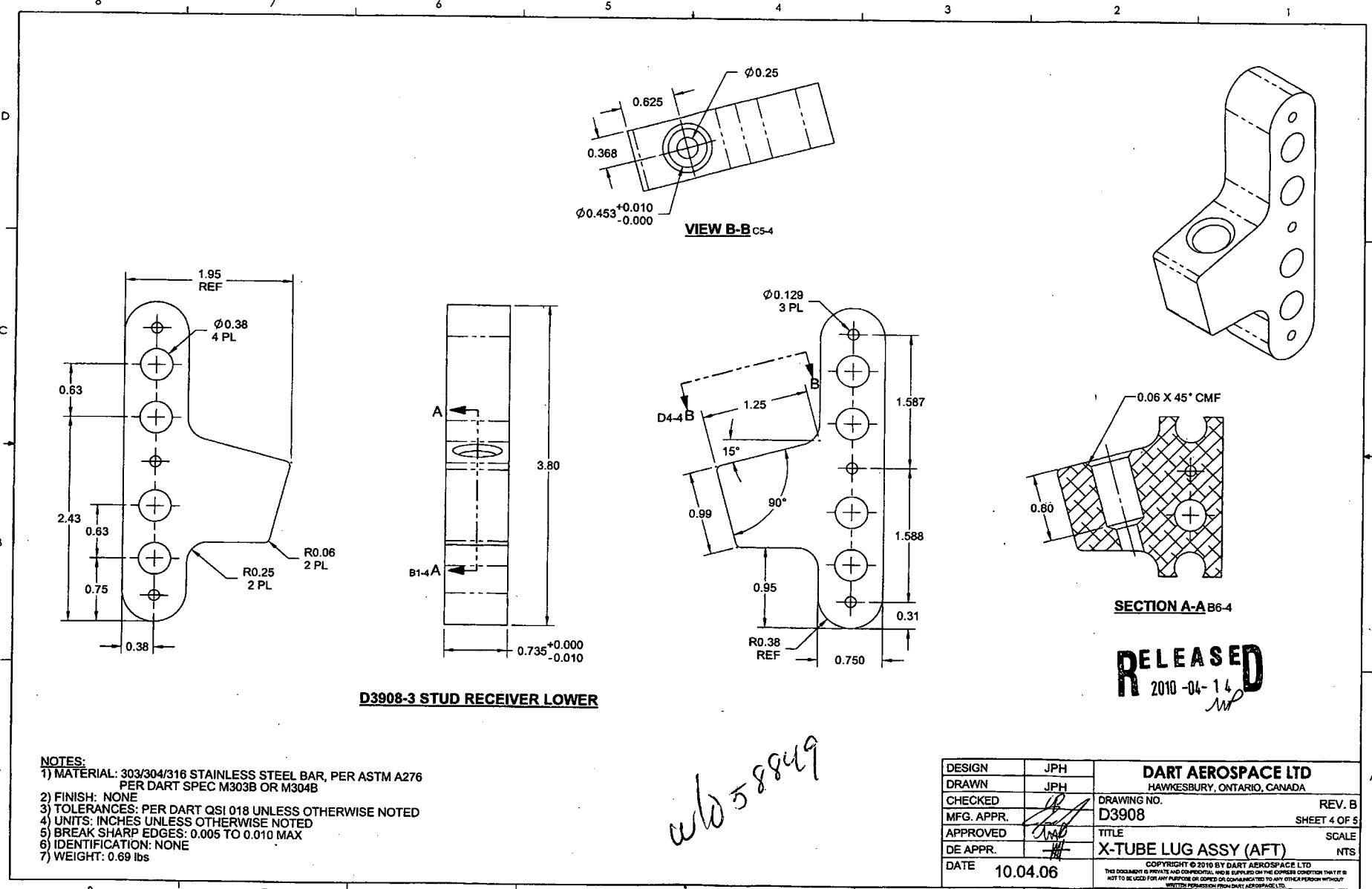
DESIGN	JPH	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D3908
APPROVED	<i>[Signature]</i>	REV. B
DE APPR.	<i>[Signature]</i>	SHEET 3 OF 5
DATE	10.04.06	TITLE
		X-TUBE LUG ASSY (AFT)
		SCALE
		NTS
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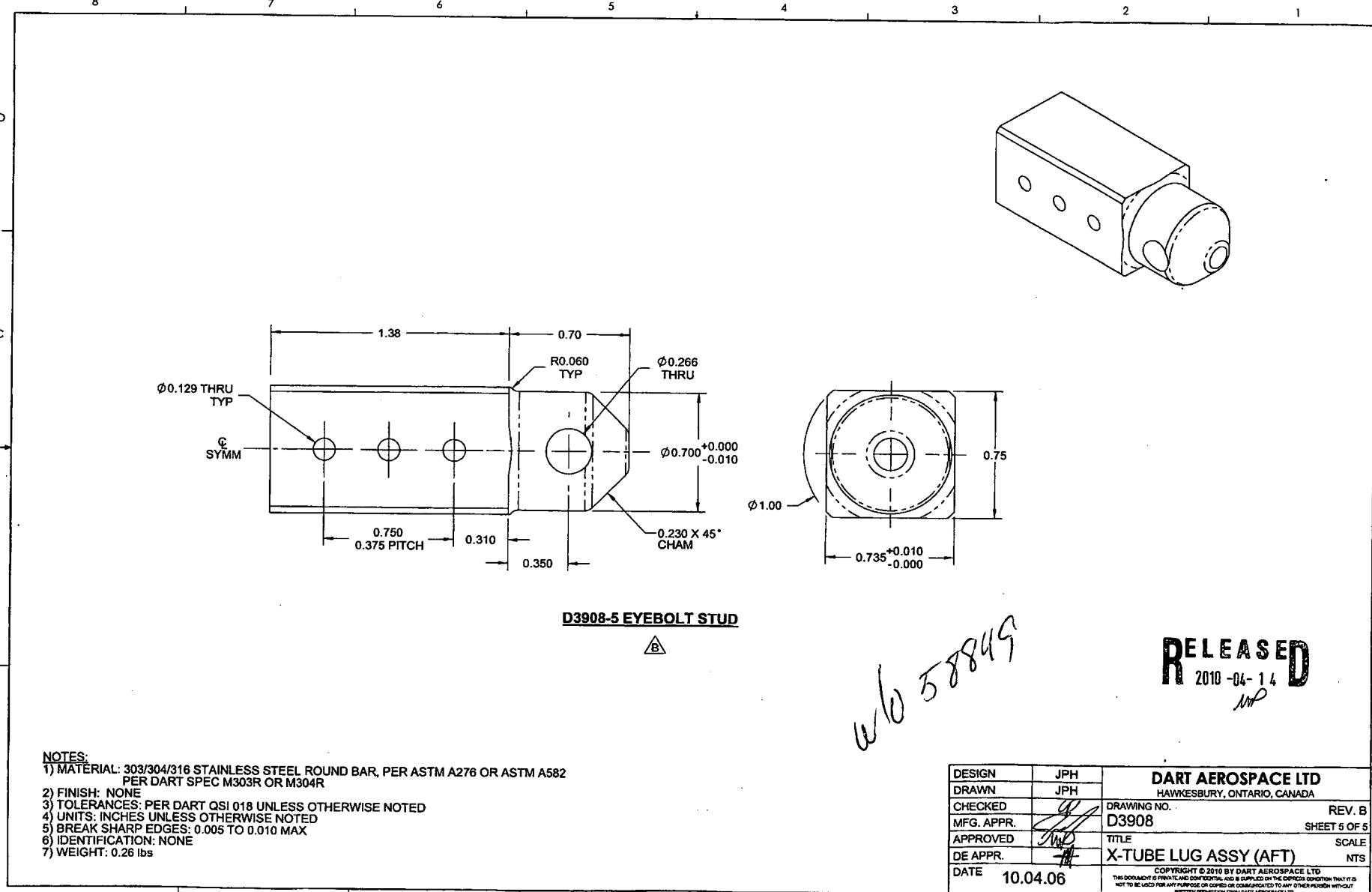


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